

Date: Tuesday, 4/11/2006 2:19:20 PM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : COVER PLATE, LH
<b>Job Number</b> : 26629	
<b>Estimate Number</b> : 12221	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D34671
<b>This Issue</b> : 4/11/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3467 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 26106	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 4/18/2006
<b>Checked &amp; Approved By</b> : SEE ABOVE USER & DATE	<b>Qty:</b> 10 Um: Each
<b>Comment</b> : est rev. A 06.02.06 new issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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**Comment:** Sub-Contracting issue P/O: 1042

Email or Ship DXF file to vendor

Laser Cut per Dwg D3467 flat pattern D3467-1F

Material release note required

C206104128

2.0	D34671F	COVER PLATE FLAT PATTERN
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Took 10 for 24980 u/o  
Same flat pattern

SB 06/05/18

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

DOUBLER FLAT PATTERN

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

SB 06/04/20 (20)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

SB 06-05-02 (20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Form as per dwg D3467

SB 06/05/18 (10)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 06/05/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 4/11/2006 2:19:20 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER PLATE, LH

Job Number: 26629

Part Number: D34671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*[Signature]* 06-05-23 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 446

*[Signature]* 6/5/24 (10)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*[Signature]* 06/05/05 (10)

Job Completion



u 06-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

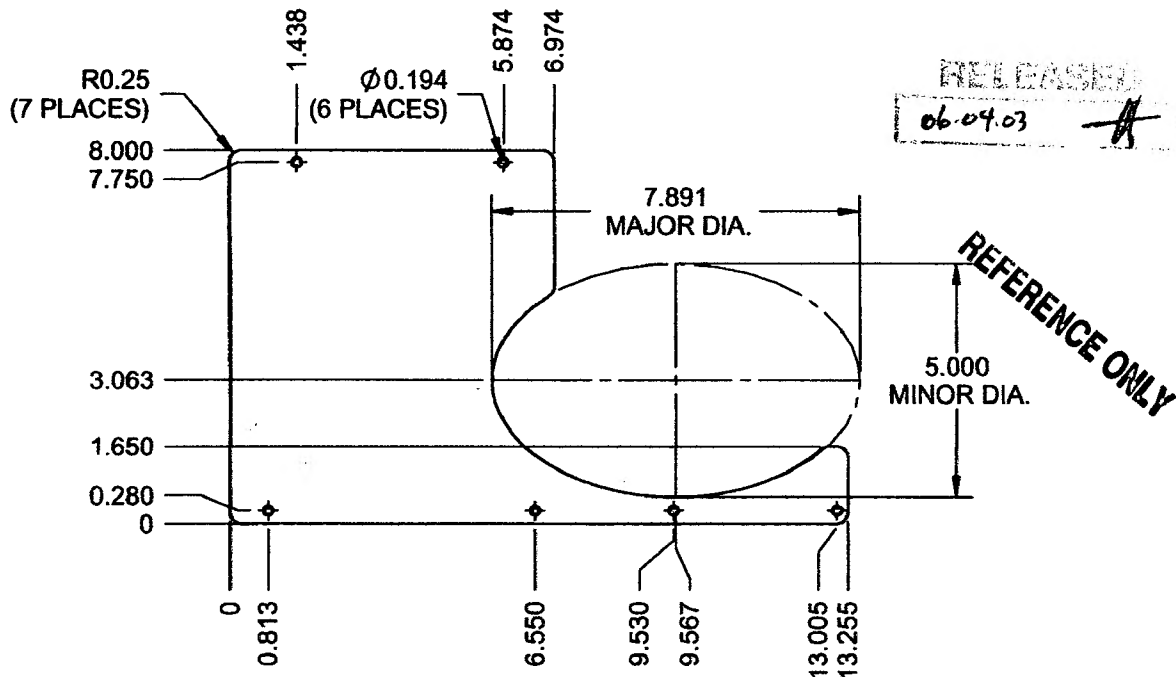
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

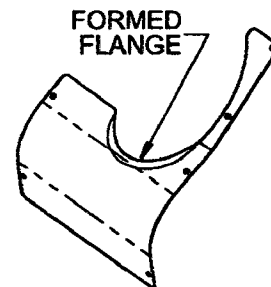
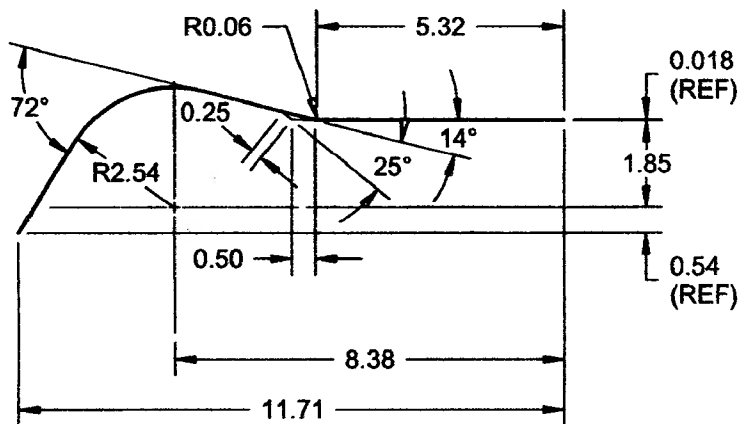
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3467</b>	REV. A SHEET 6 OF 15
DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4



### **D3467-1F COVER PLATE FLAT PATTERN**



### **D3467-1 L/H COVER PLATE ISOMETRIC VIEW,** **D3467-2 R/H COVER PLATE (OPPOSITE)** SCALE 1:8

#### **NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NORTH AMERICAN  
STAINLESS

# METALLURGICAL TEST REPORT

6870 Highway 42 East  
Ghent, KY 41045-9615  
(502) 347-6000

Certificate: 290000 02

Mail To:  
WILKINSON STEEL AND METALS  
ATTN: MILL CERTIFICATE SCANNER  
888 SOUTHEAST MARINE DRIVE  
VANCOUVER, BC V5X2V3  
CANADA

Ship To:  
WILKINSON STEEL AND METALS  
888 SOUTHEAST MARINE DRIVE  
VANCOUVER, BC V5X2V3  
CANADA

Date: 11/22/2005 Page: 1

Steel: 304

Finish: 2B

Your Order: P51013PC004

NAS Order: AE 0329272 02

Corrosion: ASTM A262/02aE/1808end-OK

## PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.  
ASTMA240/04a, 480/04a, 666/03, ASMESA240/04, SA480/04, SA666/04  
Q08766D-A X MG PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

## REMARKS:

Material free from mercury contamination. No weld repairs.  
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces
B40627	* 0679E9 A	.0240	48.0000	2,475 SHEET	120.00	2	65
B40628	* 0679E9 A	.0240	48.0000	2,485 SHEET	120.00	3	65

## CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
79E9	.057	18.152	.369	1.666	.319	.046	8.205	.029	.001	.326

## MECHANICAL PROPERTIES

Product ID #	Coil #	1 d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Tail Hard	Hard R45T
B40627	0679E9	F T	97.09	48.19	48.98	49.00	46.50
B40628	0679E9	F T	97.09	48.19	48.98	49.00	46.50

QC ENGINEER

ERIC HESS

11/22/2005

560322EM009-7 T M INDUSTRIAL (P51013PC004.79E9)

